

Work Order ID 51789

September 3, 2009 8:44:00 AM



Page 1

Item ID: D3506-1	Accept		Setup Start	
Revision ID: A			Stop	
Item Name: Doubler				
Start Date: 04/09/2009	Start Qty: 40.00		Cust Item ID:	
Required Date: 15/09/2009	Req'd Qty: 40.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>mk</u>	Date: <u>09-09-09</u>	Tooling:	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<u>Draw Nbr</u>	<u>Revision Nbr</u>					98			
D3506	Rev A								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3506	<input type="checkbox"/> Dwg Rev: <u>A</u>		<input type="checkbox"/> Prog Rev: <u>A</u>					
	Deburr if necessary								
									(98)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA640 and Dwg D3506								

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Item ID: D3506-1

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Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 04/09/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 15/09/2009 Req'd Qty: 40.00

Customer:

Reference:

2009-09-03

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*WJ
09/09/09*

98

0

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

H.A 09/09/04

98

0

150



Small Fab

Small Fab

Small Fab

Memo

C'sink as per Dwg D3506(On Flat side)

0.00

0.00

*m-k 09/09/08
m-k 09/09/03
Grind off pin*

98x

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Cust Item ID:

Required Date: 15/09/2009 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

> 5 09/09/08

count
x98

QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

MD 09/09/08

x98

HandFinish

Memo

0.00

Hand Finishing

180

QC3- Inspect Part Finish

0.00

ML 09/09/08

x98

QC

Memo

0.00

Quality Control

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Stop



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Cust Item ID:

Required Date: 15/09/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Identify as per dwg & Stock Location: <u>104</u>	0.00							
Packaging Packaging	Memo	0.00							<u>Pc 8/9/9</u> (98)
200 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							<u>09/09/09</u> <u>MF</u> 09-09-09

Picklist Print

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Work Order ID: 51789



Parent Item: D3506-1RevA



Parent Item Name: Doubler

Start Date: 04/09/2009

Required Date: 15/09/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.100		Purchased	No			110	sf	64.1716	0.3284	2881 .8034		

6061-T6 .100 Sheet

B 9-9-3

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

64.17157902

102201

64.1715790

102201

DART AEROSPACE LTD		Work Order: 51789
Description: Doubler		Part Number: D3506-1
Inspection Dwg: D3506 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

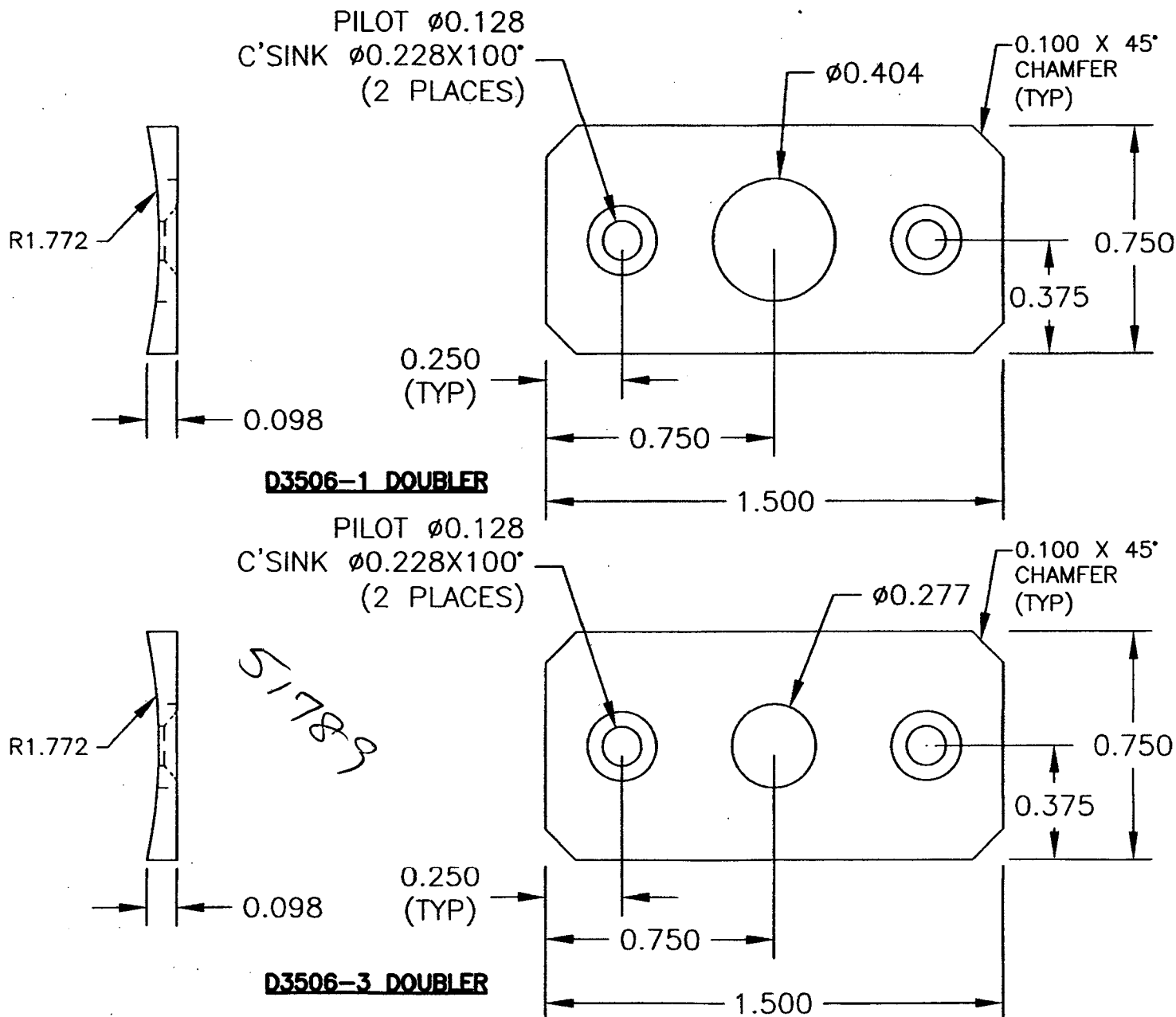
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.130	X			
Ø0.404	+0.006/-0.001	.404	*			
0.750	+/-0.010	.752	*			
1.500	+/-0.010	1.501	X			
0.375	+/-0.010	.377	X			
0.750	+/-0.010	.751	X			
0.250	+/-0.010	.249	*			
0.098	+/-0.010	.099	X			

Measured by: B MF 09/09/04	Audited by: H.A	Prototype Approval:	N/A
Date: 9-9-3	Date: 09/09/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.09	New Issue	KJ/JLM	B

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21	TITLE DOUBLER		SCALE 2:1
A	06.04.21	NEW ISSUE	

**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
06.10.03 PH
PER ESN #361

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